

Date: Tuesday, 4/25/2006 7:35:46 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ARMOR SHIELD
 Job Number : 26799
 Estimate Number : 12366
 P.O. Number : *NIA*
 This Issue : 4/25/2006 S.O. No. : *NIA*
 Prsht Rev. : NC
 First Issue : *NIA* Type : LANDING GEAR
 Previous Run : 26731
 Written By : *SEE COMMENT BELOW*
 Checked & Approved By : *06.04.25*
 Comment : Est Rev: A New Issue 06-04-19 JLM

Part Number : D212664101A
 Drawing Number : DSI9326
 Project Number : N/A
 Drawing Revision : A
 Material : *NIA*
 Due Date : 5/5/2006 Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: Photocopy bluefile & type labels per PPPD212-664-101A CHG001
 Add DSI 9326 to existing paper work.

2.0 D212664101 Crosstube Installation



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Fwd Crosstube
 Batch: *D25987*

FC 06 05 0416

3.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
 1-Remove tube from packaging

2-Apply Armor sheild as per DSI 9326
 A/R Armor Sheild Batch: *m18328*

FC 06 05 0416

4.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

W 06 05 05 (1)

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Identify and pack for shipping as per PPP D212-664-101A
 Location: *DRAFT*
 PPP Rev: *06/5/5*

DART		TEL: 1-813-632-3336 FAX: 1-813-632-1113	
TRANSPORTATION APPROVAL (0000)			
PN	D212-664-101	CHG	CHG002
DESC	Crosstube Fwd High	STC	SH01-9
ICP	B25987	STC	SR01298NY
RECEIVED	Bell 204/205/212/214/412	STC	

MADE IN CANADA

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/05/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/25/2006 7:35:46 AM
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Drawing Name: ARMOR SHIELD

Job Number: 26799

Part Number: D212664101A

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DD

06/05/05

(1)

Job Completion



U 86-05.05

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED J. J.	APPROVED J.	DRAWING NO. DSI 9326	REV. A SHEET 1 OF 1
DATE 06.02.14	TITLE ARMOR SHIELD		SCALE NTS
A	06.02.14	NEW ISSUE	

DART SERVICE INSTRUCTION

To further protect Dart crosstubes from mechanical damage in service, they may be treated with "Armor Shield" surface treatment.

INSTALLATION	CANADIAN STC	FAA STC
D205-596-101/-103/-105/-107	SH03-6	SR01742NY
D212-664-101/-201	SH01-9	SR01298NY
D412-664-203		
D206-667-101/-103/-201/-203	SH01-5	SR01304NY
D407-667-105/-205		
D058-676-101/-201	N/A	SR01018SE

To designate crosstubes with 'Armor Shield' add 'A' to the Part Number. For example, D206-667-101A is a D206-667-101 crosstube coated with Armor Shield. It is acceptable to apply the Armor Shield in regions shown in Figure 1 only. It is **NOT** acceptable to apply Armor Shield in the cuff and support/clamp regions.

1.0 To apply Armor Shield

- 1) Ensure the crosstube is appropriately finished in accordance with the relevant manufacturing drawing or Instruction for Continued Airworthiness (ICA).
- 2) Mask areas around supports and cuffs per Figure 1. Abrade paint finish in areas requiring protection using 320 grit sandpaper.
- 3) Clean/degrease surface of crosstube using Methyl Ethyl Ketone (MEK), 4105S Wash'n'Wipe Degreaser, or equivalent and wipe the surface to clean the entire area.
- 4) Apply 3 coats of Proform PF 746 or PF 746-1 to surface (apply additional coats when surface is dry, but not fully cured).
- 5) Allow 5 hours for coating to dry.
- 6) Apply 2 coats of Imron 500s Polyurethane Enamel clear + Dupont Imron Polyurethane Enamel Activator 192S (mix 3:1). Mix 15 minutes prior to application and allow 15 minutes before applying additional coats.

2.0 Armor Shield removal/re-application

To remove the Armor Shield coating or if damage to the coating and/or crosstube is observed during inspection.

- 1) Remove Armor Shield from the affected area using 80 grit sandpaper. To remove Armor Shield from larger areas, bead blasting has been determined to be the most effective technique.
- 2) Repair mechanical damage (within limits) to the crosstube and touch up finish in accordance with the relevant ICA.
- 3) Apply Armor Shield in accordance with Section 1.0 of these instructions.

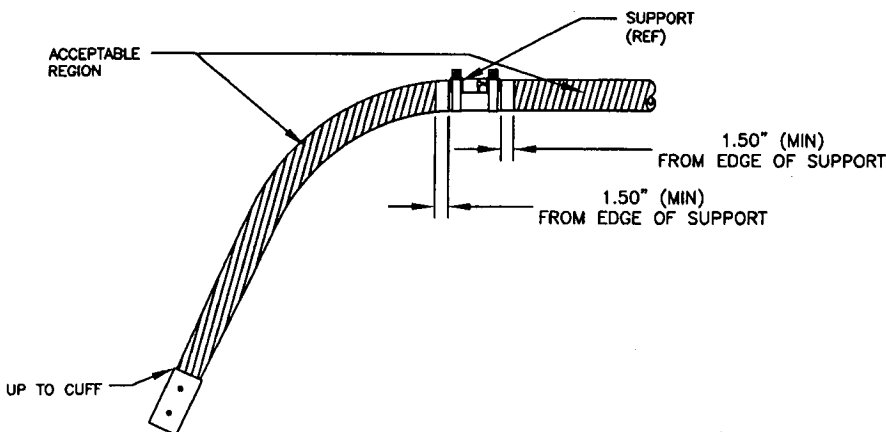


FIGURE 1 - ACCEPTABLE REGIONS TO BE COATED WITH ARMOR SHIELD

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

CANADA 26799
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 06.02.14
CERT. NO.: SH03-6/SH01-9/SH01-5
ISSUE NO.: 3/3/3

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